

Work Order ID 163144

Thursday, June 22, 2017 8:59:40 AM

163144

Page 1

Item ID: D4634-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft, Center Ceiling Panel

Stop ***NS2***

Start Date: 6/22/2017 Start Qty: 2.00

Required Date: 7/11/2017 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference: 2AG

DAS

Approvals: 13

Process Plan: 9-09

Date: JUN 22 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4634	G

110

0.00

110

Purchasing

Purchasing

THERMOFORMING MACHINE

Memo

ISSUE P/O: 36790
SUPPLIER: PLASTECH

MANUFACTURE D4634-5 AS PER DWG

C OF C IS REQUIRED

3 JUN 22 2017

DAS
13
9-09

140

0.00

140

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs
HAND FINISHING THERMOFORMING

Memo

0.00

3x 8017714.
PTO

DQA:

Date: 2017-07-21

JUL 19 2017 WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: 163144		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. D4634-5		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. NCR17-6529		Scrap ☒		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☒		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☒			
Date: 17-07-17		Step #: 140		QTY Effective: 1						MRB (QSI042) Approval	
										DAS 9 9-89 17-07-17	
Description Work Order Deviation				Disposition				Completed By			
Item This web in the corner but on the finish part can't trim see picture on NCR17-6529 R.C. supplier				Scrap/destroy No replace				17/07/17			
								Lead hand / Supervisor Approval Verification			
								17-07-17			
								QC / QA Coordinator Approval			
								DAS 9 9-89 17-07-17			
Root Cause				FAULT CATEGORY							
Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☒ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
OTHER: supplier											

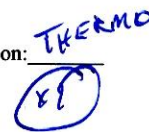
Work Order ID 163144
Thursday, June 22, 2017 8:59:40 AM

163144

Page 2

Item ID: D4634-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft, Center Ceiling Panel
Start Date: 6/22/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				2			 17-07-17
170 *170* Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00		W/O. 164046 	DAS 07 9-89 17/07/17				 17/07/17
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							17/7/18 



JUL 18 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

Picklist Print

Thursday, June 22, 2017 8:59:39 AM

Page 1

Work Order ID: 163144

163144

Parent Item: D4634-5

D4634-5

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 6/22/2017

Required Date: 7/11/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Document release DL VERIFIED BY:JLM
 Dwg Update DL verf: DD
 DL
 DL
 DL
 DL
 Verify DD

IPP Rev B
 IPP Rev C 13/07/09
 IPP Rev D Dwg Update 13/12/23
 IPP REV E Dwg update 14/01/09
 IPP Rev F Dwg. update 14/02/03
 IPP Rev G Dwg. Update 15/01/27
 IPP Rev.H 17.06.13 Now outside process DP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-5P		Purchased	No			110	Each	0.0000	1				
D4634-5P									**				
Aft, Center Ceiling Panel													
MLEXS.093-F6006-07		Purchased	No			110	sf	1,063.960	17.33	34.66			
MI FXS 093-F6006-07									**				
GE PLASTICS LEXAN SHEET (LIGHT GREY)													

Location

Loc Qty

Loc Code

MAT023

69.56

m129738

69.56

RM

994.4

m135322

194.4

m135517

800

3 3X8017-714

JUL 18 2017

34.66
51.99

DQA: _____ Date: _____

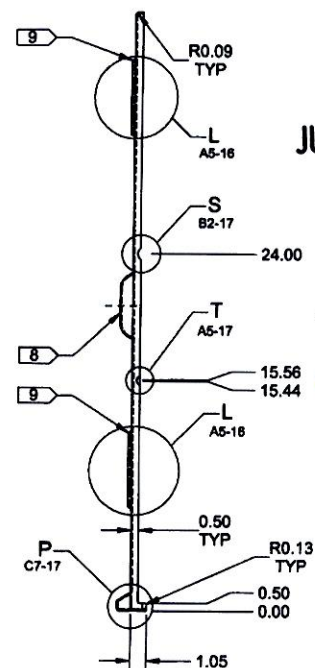
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

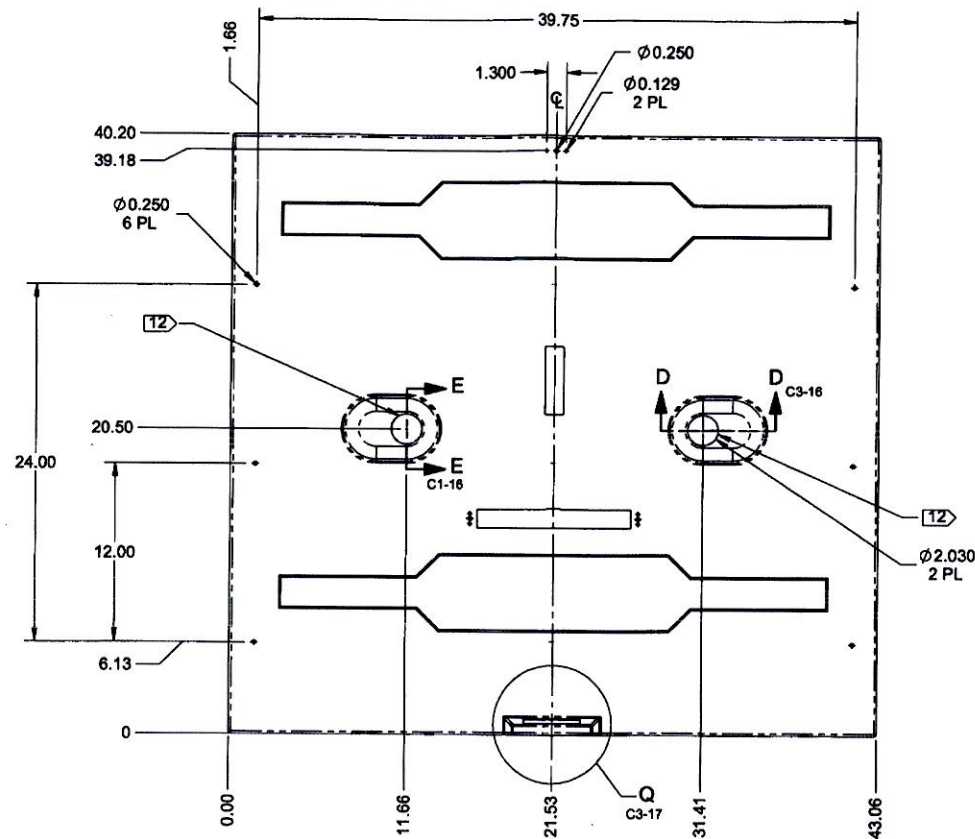


W/O: 163144

2015 JAN 26 *qp*

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 14 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

RELEASED

2015 JAN 26 *qp*

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 15 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36790**

Purchase Order Date 6/22/2017

PO Print Date 7/7/2017

Page Number 1 of 2

Order From :

VC-PLT01

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

REVISED

Contact Name

Vendor Phone

416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 60

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4634-1P	Fwd, Center Ceiling Panel	7/11/2017 Yes 7/11/2017		2.00 Each	\$141.05	\$282.10

MANUFACTURE AS PER DWG D4634 REV. G
NOTE: TRIM TO FINISHED DIMENSIONS
B163143

Line Total: \$282.10

2 D4634-5P

Aft, Center Ceiling Panel

7/11/2017
Yes
7/11/2017

3.00
Each

\$141.67 \$425.01

MANUFACTURE AS PER DWG D4634 REV. G
NOTE: TRIM TO FINISHED DIMENSIONS
B163144

SP17-7-14.

Line Total: \$425.01

Note:

7/7/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 23297
Shipment Date: 07/11/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order	Sales Order	Incoterms	Payment Method
36790	SO-019163		COL
Carrier Account #	Ship Via	Tracking Number	
CU103666	BESTWAY -		
Item Number - Revision	Description	Quantity Shipped	UOM
D4634-1P - Rev.: G	FWD, CENTER CEILING PANEL	2	EA
	HS Code: 3920.61.1000 - OTHER		
	Country of Origin : CA		
D4634-5P - Rev.: G	AFT, CENTER CEILING PANEL	3	EA
	HS Code: 3920.61.1000 - OTHER		
	Country of Origin : CA		

8017-7-14

Number of Containers

Gross Weight

Shipped By

